



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE350A93-3316-20-1

Job Sheet 171149



Part No: RBE350A93-3316-20-1

Job Qty: 6 ea

Part Name: Rotating Star Replacement Wrench



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/29/18

Job Tracking No:

Due Date: 2/9/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A93-3316-20-1 REV:C IPP REV A 18.01.23 NEW ISSUE RQ VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		2/8/18	0.00	0.00	Start Up Machining-4		
100	CNC Lathe	6 pcs		2/9/18	0.00	12.00	MORI SE-154 NLX-2500		
110	QC	6 pcs		2/9/18	0.00	0.00	QC2 Machining-5		
130	QC	6 pcs		2/9/18	0.00	0.00	QC8 Machining-5		
230	Packaging	6 pcs		2/9/18	0.00	0.00	Packaging3-2		
240	QC21-SA	6 Ea		2/9/18	0.00	0.00	QC21		

Part Op 100 - 1-Machine as per folio FB 374 FOLIO REV: _____ DWG REV: _____ 2-Broach as per dwg.

Descriptions: 3-Deburr

230 - IDENTIFY AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H900-R2.750	17-4 SS H900 Round Bar 2.750"	.7500 ft (.125 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H900-R2.750	1	0	0

Part Specifications

Specifications could not be found.

Plex 1/29/18 3:00 PM Dart.lajeunesse.marie



Container No: S046619



Part: RBE350A93 - 3316 - 20 - 1

Job No: 171149

Serial No/Batch: S046619

Revision: C

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/28/18

DQA: _____ Date: _____



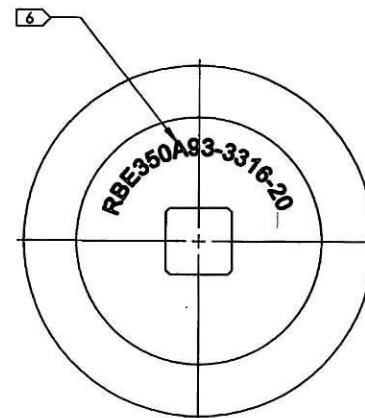
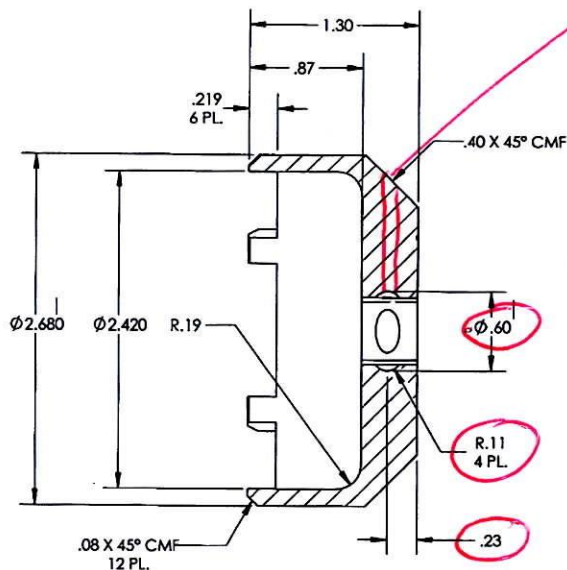
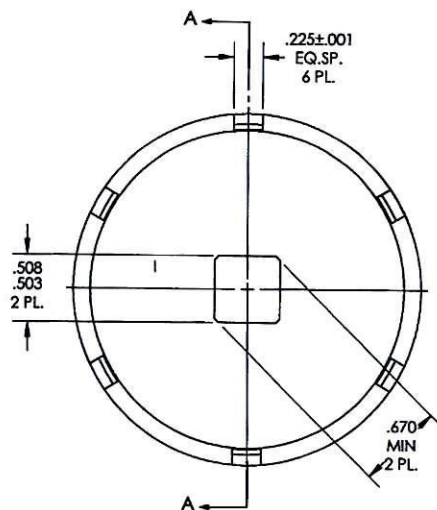
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. <u>R3E360A93-3316-20-1</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval <u>02/28/18</u>																																																																	
Description Work Order Deviation DRILL ONE 0.161" HOLE PERPENDICULAR TO ONE OF THE (0.603-0.508) FACES INSTEAD OF MACHINING THE RADIUS ON THE (0.603-0.508) FACES				Disposition THIS DEVIATION IS ACCEPTABLE SET, FORM & FUNCTION WILL BE AS ORIGINALLY INTENDED		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																																	
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REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
C	TEMPLATE UPDATED, MATERIAL 4140 CHANGED FOR 17-4 PH H900, FINISH BLACK OXIDE REMOVED, DIMENSION .232/.222 CHANGED FOR .225 +/- .001 PER CUSTOMER SUPPORT INFO, CMF .08x45° 6 PL. CHANGED FOR .03x45° 12 PL., ENGRAVING CHANGED FOR MACHINED ENGRAVE	17-800	17.12.22	VM	ML



RBE350A93-3316-20-1 ROTATING STAR REPLACEMENT WRENCH

NOTES:

- 1) MATERIAL: 17-4 PH-H900 SS
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
- 6) IDENTIFICATION: MACHINE ENGRAVE AS SHOWN, 0.010" DEEP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 1711401105
180129 M Lee

DART AEROSPACE Hawkesbury, Ontario, Canada	
TITLE ROTATING STAR REPLACEMENT WRENCH	
PART NO. RBE350A93-3316-20-1	REV C
TOOL NO. RBE350A93-3316-20	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES FOR ASSEMBLY ARE: DIMENSIONS APPLY AFTER FINISHING	
DESIGNED BY: VM 17/12/22	TOLERANCES: XXX ±.008 FRACTIONS ± 1/8
DRAWN BY: VM 01/02/2018	XX ±.01 ANGLES ±.5°
CHECKED BY: VM 01/02/2018	X ±.1 SURFACE
INFO REVIEW BY: DD 01/02/2018	ROUGHNESS
APPROVED BY: ML 01/05/2018	SCALE: NTS SHEET 2 OF 6
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